

Work Order ID 151712

Friday, October 07, 2016 2:33:23 PM

151712

Page 1

Item ID: D2934 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle Spacer
Start Date: 10/5/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 10/7/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: V.S. (N) Date: 10/10/11 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2934	Rev B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.03							
FLOW CNC Waterjet	1-Cut as per Dwg D2934 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.02							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.03							
Quality Control									

P.T.O.DAS
38
9-89
OCT 17 2016

DQA:

Date:

Jan 4 2017



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 16-6145 Date: 9/07/2017

Work Order update only ☐

Work Order: <u>151712</u> Part No. <u>D2934</u> NCR No. <u>16-6145</u>		DISPOSITION Rework ☒ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☒ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date: <u>16-10-13</u>		Step #: <u>100</u>		QTY Effective: <u>10</u>			MRB (QSI042) Approval DAS 9 9-89/16-10-13		
Description Work Order Deviation				Disposition				Completed By	
operator used wrong material (used stainless instead of aluminium)				scrap qty 10* and re cut to drawing using correct material. New FAI required.				Lead hand / Supervisor Approval Verification DAS 9 9-89/16-10-21	
								QC / QA Coordinator Approval DAS 9 9-89/16-10-21	
Root Cause Environment ☐ No Re-verification ☐ Design ☒ Operator ☒ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☒ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER :							

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Friday, October 07, 2016 2:33:23 PM

151712

Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130						(X12)	✓		2016/10/17
HandFinish	Memo	0.03							BEB
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							DAS
140						(12)			38
QC	Memo	0.02							9-89
Quality Control									OCT 17 2016
150	Identify as per dwg & Stock Location: <u>ST014</u>	0.00							
150						12			
Packaging	Memo	0.02							600
Packaging									9-89

OCT 20 2016

Work Order ID 151712

Friday, October 07, 2016 2:33:23 PM

151712

Page 3

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.17							
Quality Control									

DAS
21
9-89 OCT 20 2016

VS 16/10/20



Picklist Print

Friday, October 07, 2016 2:33:23 PM

Page 1

Work Order ID: 151712

151712

Parent Item: D2934

D2934

Parent Item Name: Saddle Spacer

Start Date: 10/5/2016

Required Date: 10/7/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A00.06.06New IssueEC
IPP Rev:B Now 6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		100	sf	118.4700	0.0318	0.334737			

M6061T6S 080

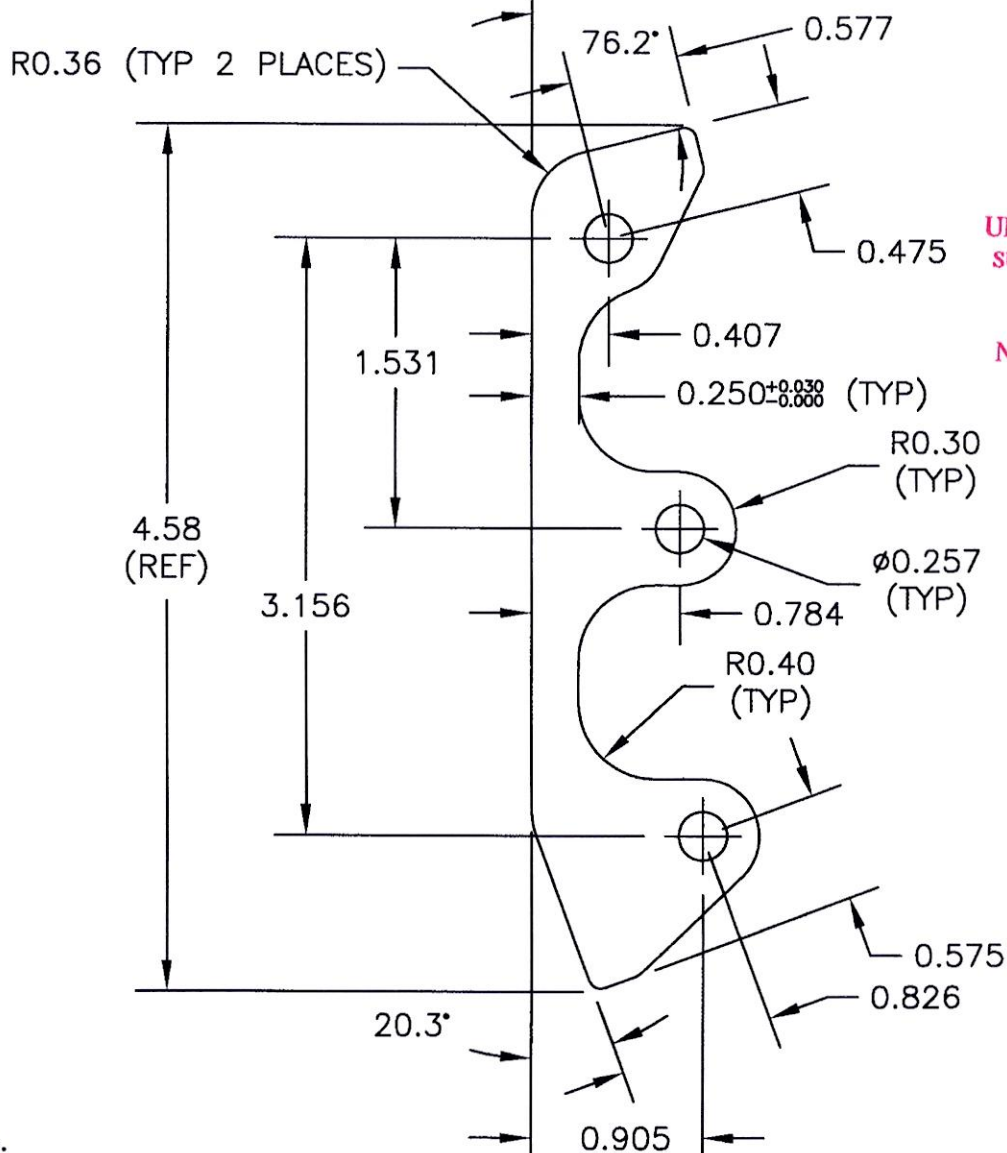
6061-T6 .080 Sheet

ac 11e/10/13

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	118.47	
134217	9.1	
m132772	4.3	
m133587	7.7	
m133828	2.6	
m134551	7	
m134830	21.9	
m135147	21.9	.7
m135377	8.1	
m135559	35.87	

DART

DESIGN #7	DRAWN BY C.B.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2934	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151712

VLC
[Signature]
16/10/11

RELEASED

06.06.20 [Signature]

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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